

Work Order ID 164621

Tuesday, July 25, 2017 7:45:49 AM

164621

Page 1

Item ID: D3065-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Leg

Start Date: 7/25/2017 Start Qty: 40.00

40

Cust Item ID:

Required Date: 8/4/2017 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100

0.03

100

FLOW WATER JET

Waterjet

Memo

1.86

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: BProg Rev: B

2-Deburr if necessary

(40)

02/17/08/13

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.40

Quality Control

(40)

02/17/08/13

164621

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N900040100

Setup Start *NS1*

Stop *NS2*

40

Cust Item ID:

40

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.80

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.87

Hand Finishing

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.40

Quality Control

Work Order ID 164621

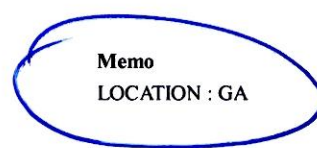
Tuesday, July 25, 2017 7:45:49 AM

164621

Page 3

Item ID: D3065-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Leg
Start Date: 7/25/2017 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Packaging Packaging	Identify as per dwg & Stock Location:   Memo LOCATION : GA	0.00 0.40				<u>40</u>	<u>AUG 18 2017</u>		
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 4.00					<u>17/8/15</u>		

UM 7/8/18

9-89
6
DASDAS
21
9-89

Picklist Print

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Page 1

Work Order ID: 164621

164621

Parent Item: D3065-5

D3065-5

Parent Item Name: Step Leg

Start Date: 7/25/2017

Required Date: 8/4/2017

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: C02.11.01 Incorporated D3066-1 IPPKJ/RF
IPP Rev:D Now on Water Jet 06-04-11 JLM
IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

71.0500

0.825

34.73684

M6061T6S 080

217/08/13

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT020

71.05

m136342

5.75

m136632

0.3

m137513

1

m138066

64

i38109

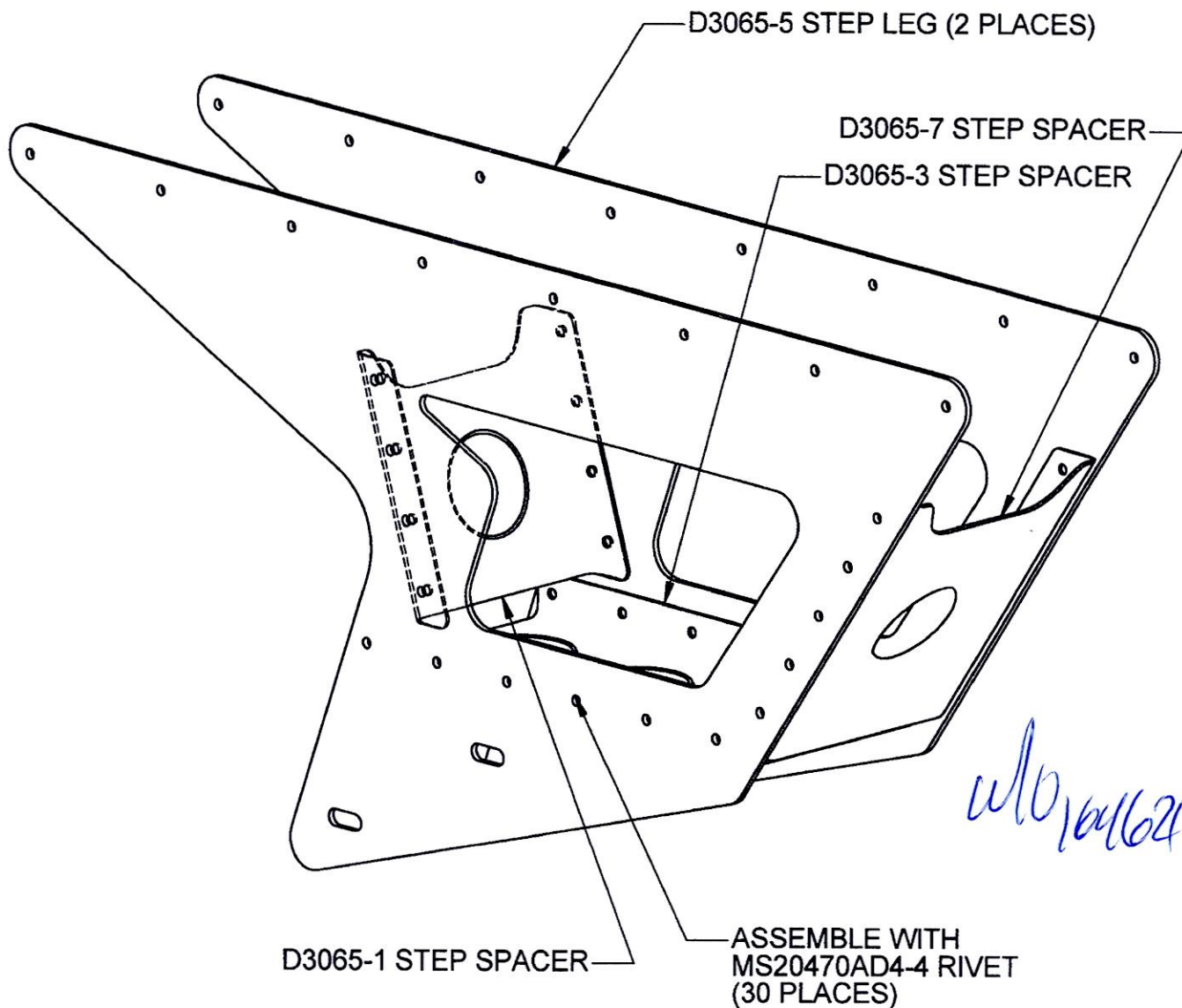
32



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06-06-20 *[Signature]*



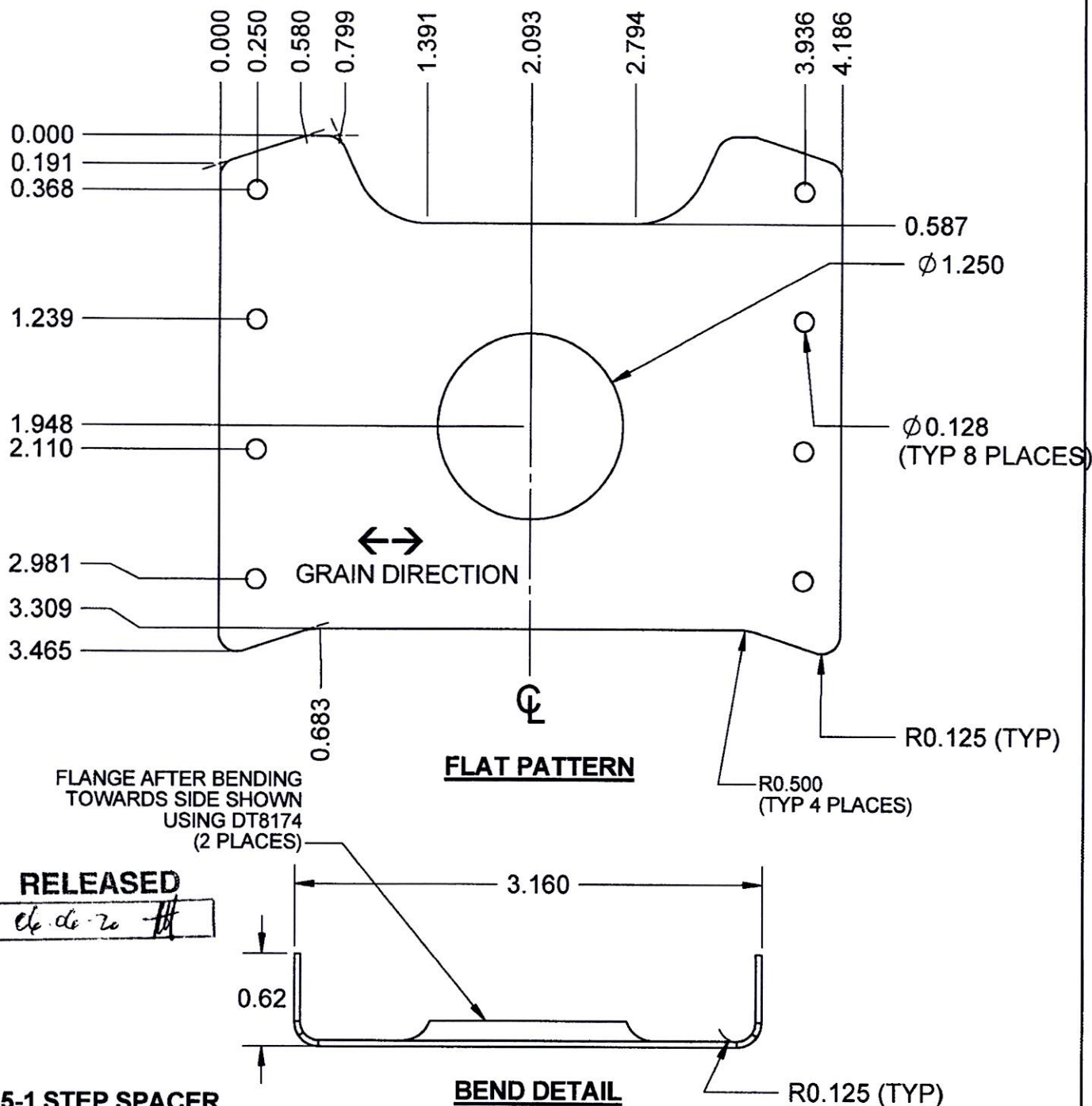
D3065-041 STEP LEG ASSEMBLY

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DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



D3065-1 STEP SPACER

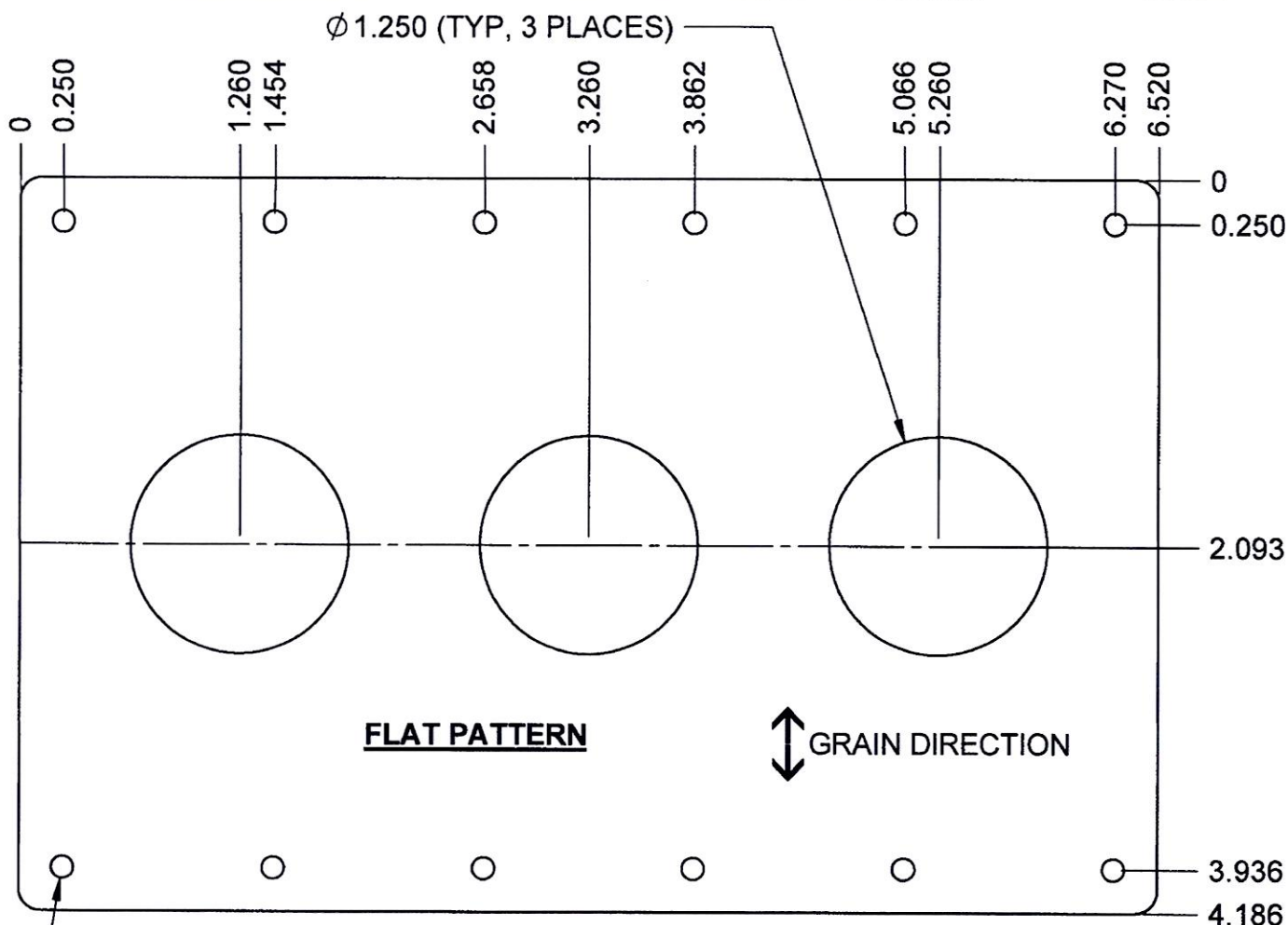
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

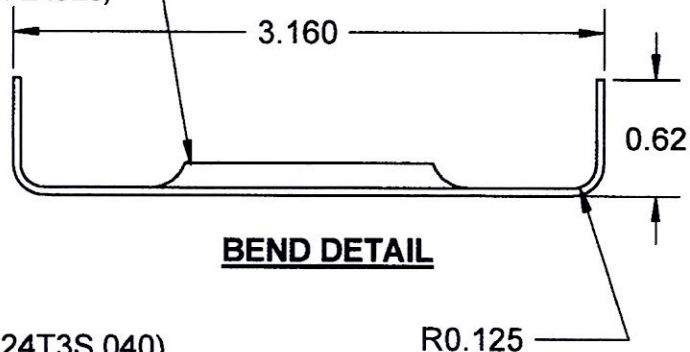


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06.05.23 *[Signature]*



BEND DETAIL

D3065-3 STEP SPACER

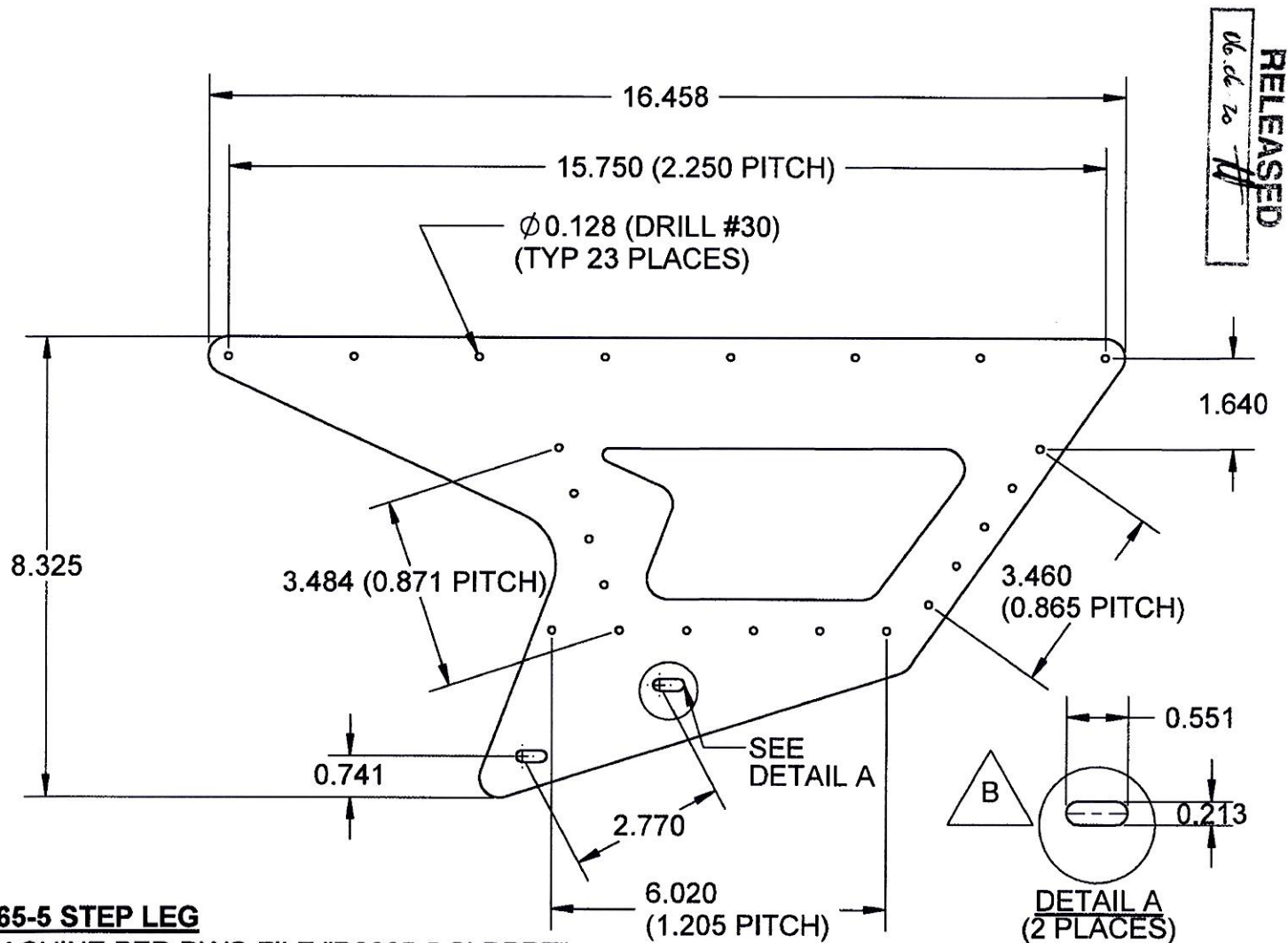
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	APPROVED	<i>CB</i>	DRAWING NO.
				D3065
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY	
		SCALE	1:3	REV. B SHEET 4 OF 5



D3065-5 STEP LEG

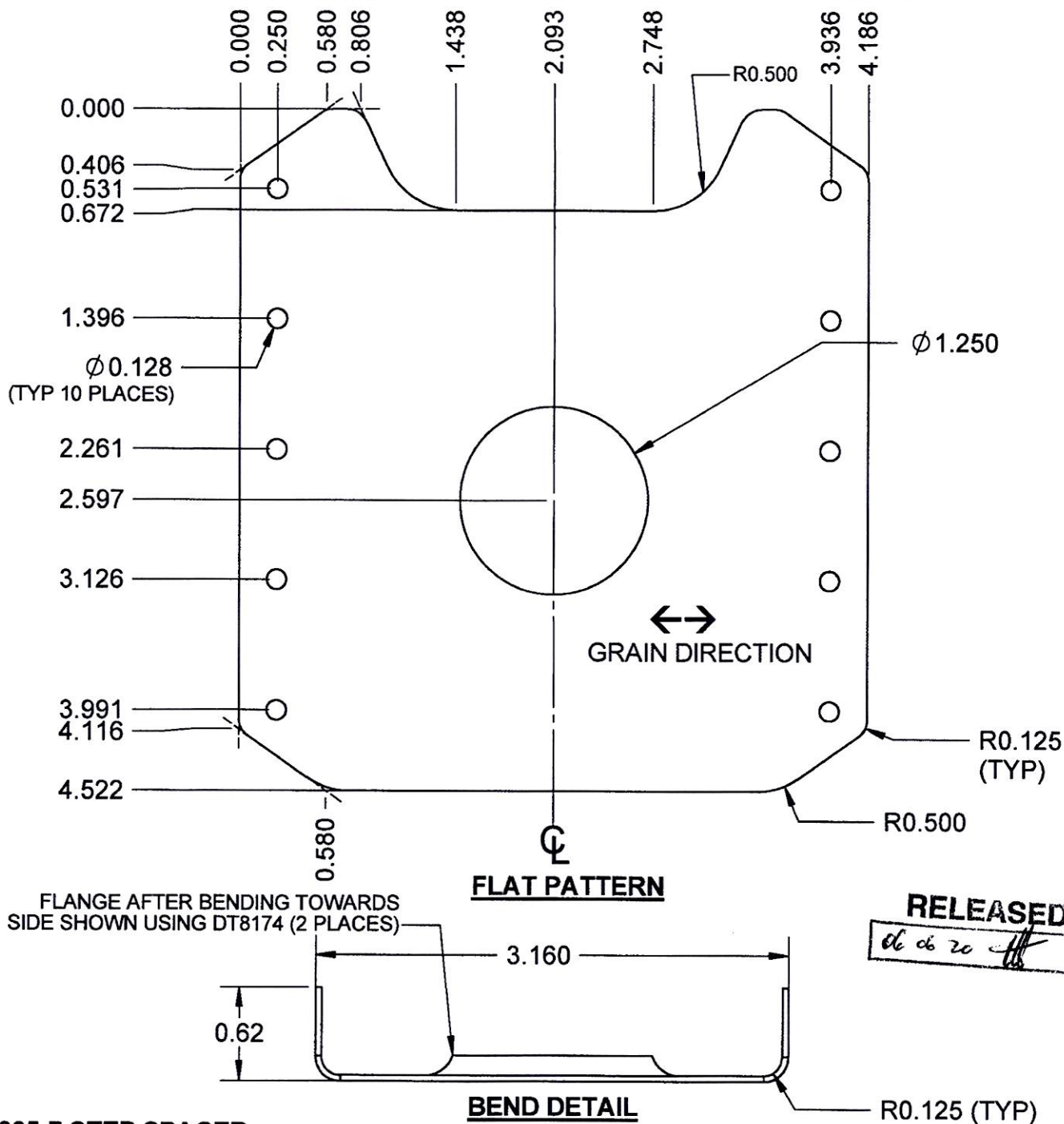
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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